

BOX JIGS

ing points, however, are somewhat hidden from view when the piece is inserted. The jig shown in Fig. 8 consists of only one casting *L*, provided with feet, and resembles an open drill jig. The work is located in a manner similar to that already described, and the leaf *D*, wide enough to take in all the bushings except the one for the hole that must be drilled from the opposite side, is fitted across the jig and given a good bearing between the lugs in the jig wall. It swings around the pin *E* and is held down by the eye-bolt *F* with a nut and washer. Sometimes a wing-nut is handier than a hexagon nut. Care should be taken that

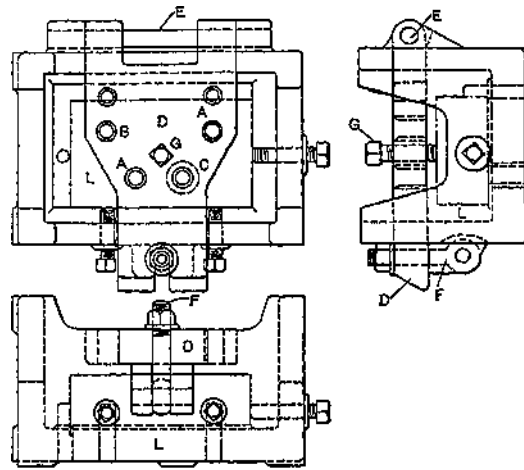


Fig. 8. Alternative Design of Jig in Fig. 7

the feet reach below the top of the nut and screw. The set-screw *G* holds the work down, and takes the thrust when the hole from the bottom side is drilled. The three holes *A*, *A* and *B* are drilled from the top so that the thrust of the drilling of these three holes will be taken by the bottom of the jig body *L*. If one set-screw *G* is not sufficient for holding the work in place, the leaf may be made wider so as to accommodate more binding screws.

It is, however, an objectionable feature to place the clamping screws in the bushing plate. If the leaf has not a perfect fit in its seats and on the swiveling pin, the screws will tilt the leaf